

SEE DSI

Custom SO128658

Work Order ID 160109

Friday, April 21, 2017 10:53:33 AM

160109

Page 1

Item ID: D3913-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Base Assembly, 350
 Start Date: 4/27/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/2/2017 Req'd Qty: 1.00 *1* Customer:
 Reference: SCHEDULED/C CUSTOM
 Approvals: Process Plan:  Date: APR 21 2017 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	C
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 136158 0.00

100

Large Fab

Large Fab

Memo

3.18

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.02

MAY 12 2017

DAS
24
9-89

1 CC 17-5-12

① 17.05.12

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
QC / QA Coordinator Approval 									

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____					
☐ Misidentified	☐ Past Due						

160109

Page 2

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 4/27/2017 **Start Qty:** 1.00 ***1***

Required Date: 5/2/2017 **Req'd Qty:** 1.00 ***1***

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

120

0.02

① 17.05-12

DAS
9
9-89

0.00

125

0.44

101705-16.

DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

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Page 3

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Required Date: 5/2/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C CUSTOM

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130 Powdercoat Powder Coating	Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat <i>M 137176</i> 1ST COAT: <i>10:45</i> START TIME: <i>375°</i> OVEN TEMPERATURE: <i>11:00</i> FINISH TIME: <i>11:00</i> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.68						<i>1</i> <i>17-05-16</i> <i>34</i> <i>9:09</i>	
140	QC3- Inspect Part Finish	0.00							
140 QC Quality Control	Memo	0.01							<i>DAS</i> <i>38</i> <i>10-2017</i> <i>MAY 17 2017</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 4/27/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/2/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C CUSTOM

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Assemble as per dwg Memo Pick Kit	0.00 0.53						6 9-89	MAY 16 2017
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.02				1		38 9-89	MAY 17 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>616</u> Memo	0.00 0.01							<u>04030-041 / B10610.1</u> <u>6 d 11 1703/11</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 160109

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160109

Page 5

Item ID: D3913-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Long Basket Base Assembly, 350
Start Date: 4/27/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/2/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C CUSTOM

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

17/5/18 

DAS
21
9-89

MAY 17 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Friday, April 21, 2017 10:53:32 AM

Page 1

Work Order ID: 160109

160109

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/27/2017

Required Date: 5/2/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24
AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG
REV.C / ECN 13-624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3913-1 ✓ *D3913-1* Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				4					
				157756				4					
D3913-3 ✓ *D3913-3* Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				4					
				146448				2					
				157564				2					
D3913-7 ✓ *D3913-7* Rib		Manufactured	No			100	Each	6.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				6					
				156428				6					
								2					
D3913-9 ✓ *D3913-9* Hinge Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA004				4					
				155678				4					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

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Work Order ID: 160109

160109

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/27/2017

Required Date: 5/2/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D3916-5
D3916-5
Light Rib

Manufactured	No	100	Each	6.0000	3	3
				**	CC 17-5-9	

✓ D3916-041
D3916-041
Rib Assembly

Manufactured	No	100	Each	8.0000	2	2
				**	CC 17-5-9	

✓ D4017-7
D4017-7
Rib

Manufactured	No	100	Each	10.0000	3	3
				**	MAY 1 2 2017	

✓ D4017-9
D4017-9
Rib

Manufactured	No	100	Each	8.0000	2	2
				**	MAY 1 2 2017	

Location	Loc Qty	Loc Code
WA004	6	B160517 → (3x)
157751	6	
WA004	8	
157746	8	(2x)
WA004	10	B160510 → (2x)
158860	10	(1x)
WA004	8	B160506 → (2x)
155938	2	
157621	6	

DAS
24
9-89

DAS
24
9-89

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/27/2017

Required Date: 5/2/2017

Start Qty: 1.00

Required Qty: 1.00

D4034-041

Manufactured No

100

Each

5.0000

1

1

D4034-041

Aft Upper Rib Assembly

**

CC 17-5-9

Location

Loc Qty

Loc Code

WA004

5

1

4

152920

157479

B160516 →

(1x)

D4034-043

Manufactured No

100

Each

5.0000

1

1

D4034-043

Fwd Upper Rib Assembly

**

CC 17-5-9

Location

Loc Qty

Loc Code

WA004

5

1

4

153910

157739

(1x)

D2581

Manufactured No

100

Each

88.0000

2

2

D2581

Mounting Bracket

**

CC 17-5-9

Location

Loc Qty

Loc Code

WA004

88

38

26

24

152803

157620

159116

(2x)

D2931

Manufactured No

150

Each

1,370.000

2

2

D2931

Bumper

**

MAY 16 2017

Location

Loc Qty

Loc Code

ST013

70

86435

70

ST025A

1300

86435

1300

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, April 21, 2017 10:53:33 AM

Page 4

Work Order ID: 160109

160109

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/27/2017

Required Date: 5/2/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D3913-15
D3913-15
Wide Handle Plate

Manufactured No

100 Each 19.0000 1 1

**

CC 17-5-9

Location

Loc Qty

Loc Code

WA004

19 ~~B157~~
19

157671

100 Each 69.0000 3

**

CC 17-5-9

✓ D4016-1
D4016-1
Hinge Half, Base

Manufactured No

Location

Loc Qty

Loc Code

WA004

69

154145

17

155346

12

158630

40

100 Each 45.0000 3

**

CC 17-5-9

✓ D4021-1
D4021-1
Handle Plate

Manufactured No

Location

Loc Qty

Loc Code

WA004

45

157523

30

159375

15

100 Each 19.0000 2

**

CC 17-5-9
MAY 16 2017
DAS 6
9-89

D4021-5
D4021-5
Blanking Plate

Manufactured No

Location

Loc Qty

Loc Code

ST071

19

155240

2

156433

6

157458

11

Friday, April 21, 2017 10:53:33 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval ☐		
Description Work Order Deviation				Disposition				Completed By _____	
								Lead hand / Supervisor Approval Verification ☐	
								QC / QA Coordinator Approval ☐	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Picklist Print

Friday, April 21, 2017 10:53:33 AM

Page 5

Work Order ID: 160109

160109

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/27/2017

Required Date: 5/2/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D4020-11

Manufactured No

100

Each

21.0000

2

2

**

MAY 12 2017

DAS
24
9-89

D4020-11

End Mesh, Basket

Location

Loc Qty

Loc Code

WA004

21

152541

1

154521

2

156918

10

157499

8

✓ D4672-1

Manufactured No

100

Each

24.0000

2

2

**

MAY 12 2017

DAS
24
9-89

D4672-1

Blanking Plate

Location

Loc Qty

Loc Code

WA004

24

153098

7

157497

17

M304EX0.75-16F

Purchased

No

100

sf

450.5000

33

33

**

MAY 12 2017

DAS
24
9-89

M304EX0 75-16F

Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA004

450.5

M136991

30.5

M137294

420

MS20600-AD4W3

Purchased

No

150

Each

218.0000

2

2

**

MAY 16 2017

DAS
6
9-89

MS20600-AD4W3

Cherry Rivet

Location

Loc Qty

Loc Code

ST308

158

m135603

158

WA003

60

m136648

60

Friday, April 21, 2017 10:53:33 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

Friday, April 21, 2017 10:53:33 AM

Work Order ID: 160109

160109

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/27/2017

Required Date: 5/2/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No

150 Each 2,126.000 6 6

MS21042L3

Nut

MAY 16 2017
DAS
6
9-89

Location	Loc Qty	Loc Code
FP001	100	
m135945	100	
GA	168	
m134360	102	
M136665	66	
OVER007	1300	
m134360	0	
M136665	300	
m137321	1000	
ST303	558	
m137073	58	
m137166	500	

NAS1149F0332P Purchased No

150 Each 1,410.000 12 12

NAS1149F0332P

Washer

MAY 16 2017
DAS
6
9-89

Location	Loc Qty	Loc Code
GA	275	
m133709	275	
ST262	1135	
m136835	8	
m137075	1127	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, April 21, 2017 10:53:33 AM

Page 7

Work Order ID: 160109

160109

Parent Item: D3913-041

D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 4/27/2017

Required Date: 5/2/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

150 Each 236.0000 6 6

AN3-10A

**

MAY 16 2017

Bolt

Location Loc Qty Loc Code

GA 60

m136787 60

ST349 176

m137321 176

NAS1149DN832J Purchased No

150 Each 750.0000 2 2

NAS1149DN832.J

**

MAY 16 2017

Washer

Location Loc Qty Loc Code

ST264 750

M135297 750

DAS
6
9-89

DAS
6
9-89

DAS
24
9-89

MAY 12 2017

ASI 9776-013

qty 1

3160995

17.05.05

ASI 9776-015

qty 1

3160994

MAY 12 2017

DAS
24
9-89

Bushing) D5338-1 → B159303 → (4x) CC 17-5-9

Friday, April 21, 2017 10:53:33 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

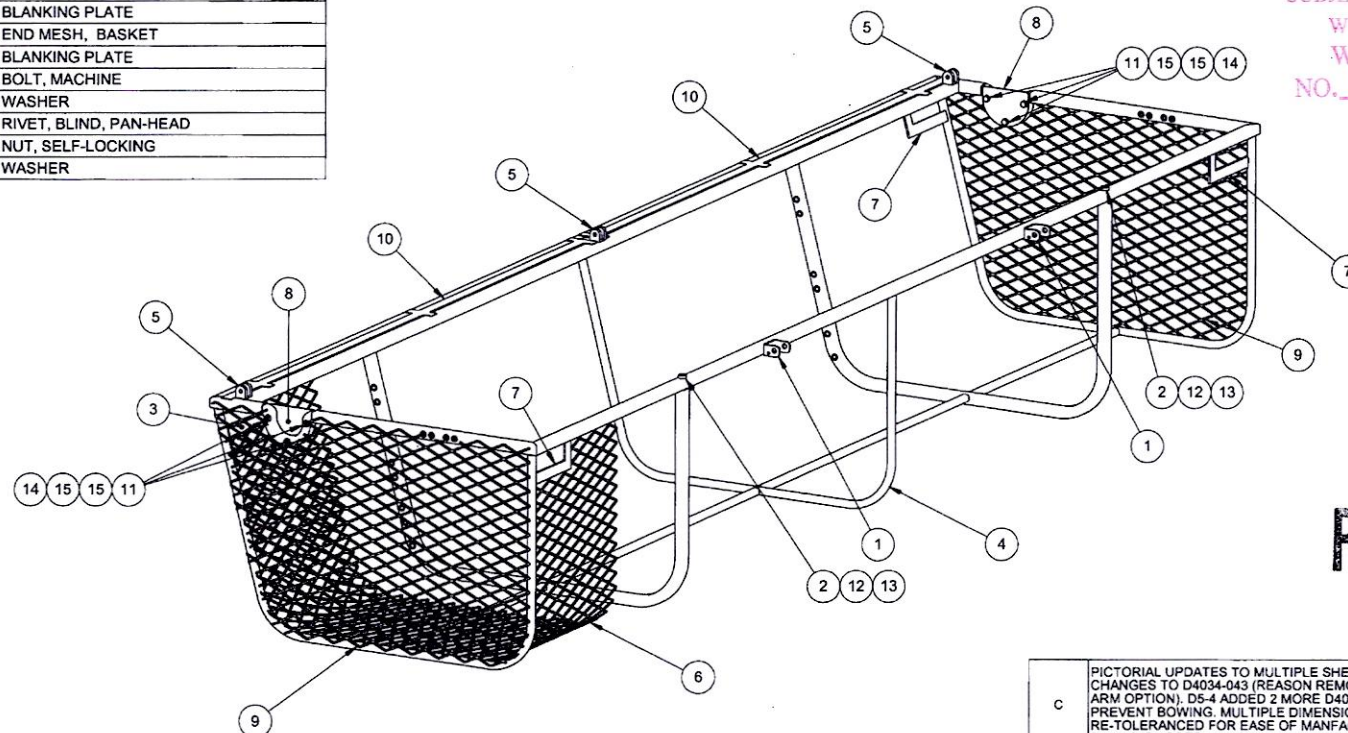
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	2	D2581	MOUNTING BRACKET
2	2	D2931	BUMPER
3	1	D3913-15	WIDE HANDLE PLATE
4	1	D3913-101	TUBULAR ASSY (350 LONG BASKET)
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	3	D4021-1	HANDLE PLATE
8	2	D4021-5	BLANKING PLATE
9	2	D4020-11	END MESH, BASKET
10	2	D4672-1	BLANKING PLATE
11	6	AN3-10A	BOLT, MACHINE
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET, BLIND, PAN-HEAD
14	6	MS21042L3	NUT, SELF-LOCKING
15	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

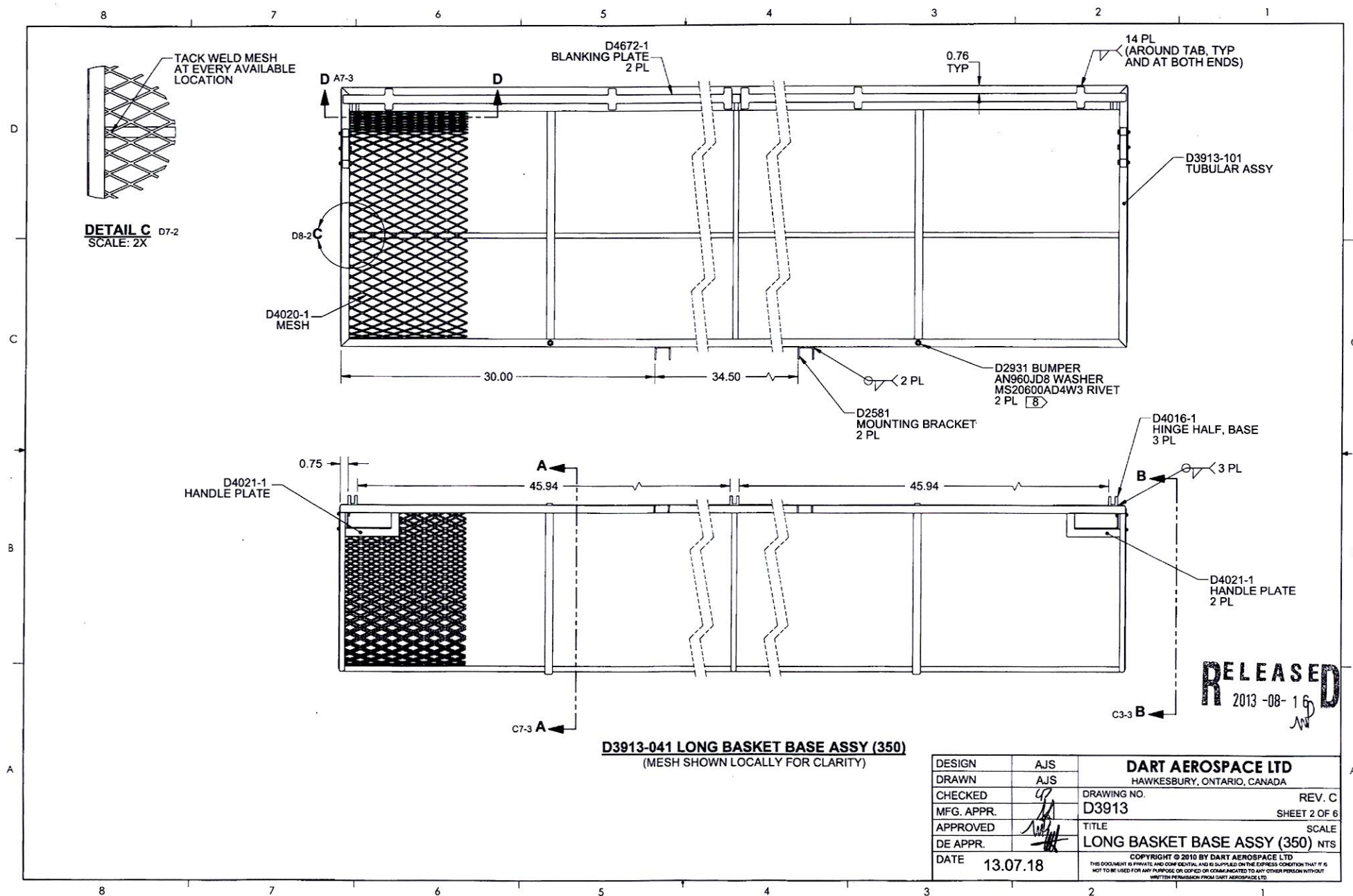
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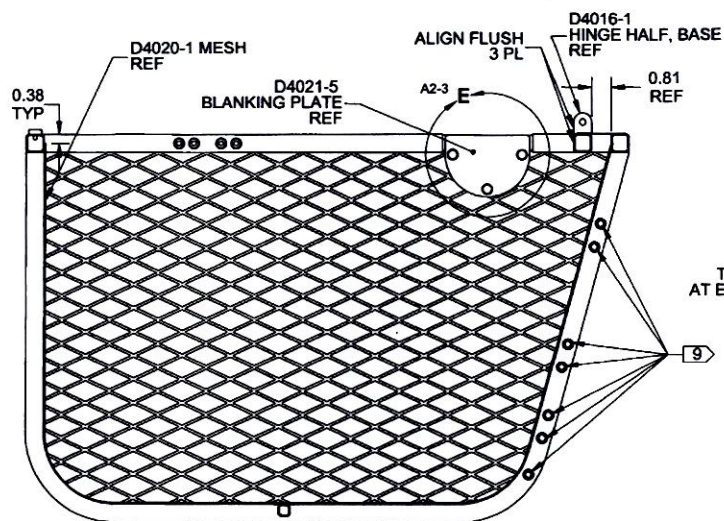
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.9 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160109
APR 21 2017

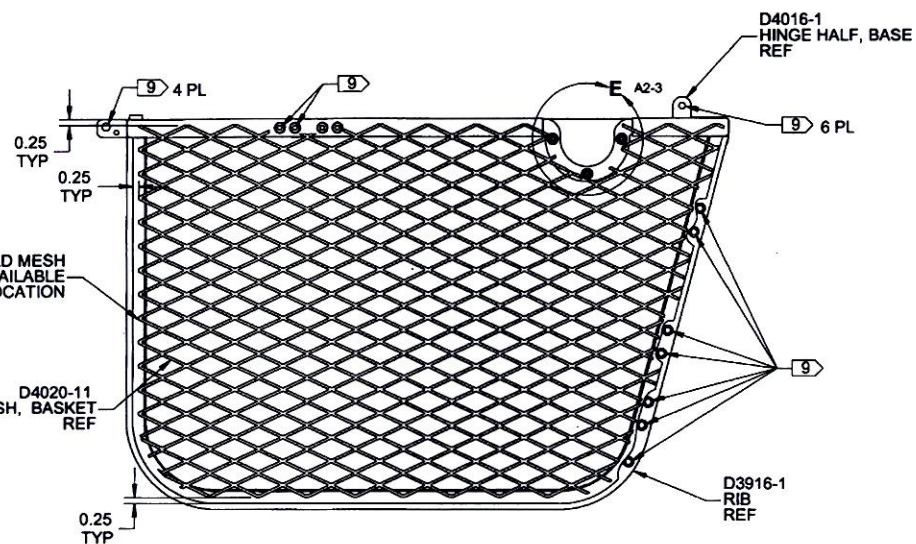
RELEASED
2013-08-16

C	PICTORIAL UPDATES TO MULTIPLE SHEETS FOR CHANGES TO D4034-043 (REASON REMOVAL OF PROP ARM OPTION). D5-4 ADDED 2 MORE D4017-7 RIBS TO PREVENT BOWING. MULTIPLE DIMENSIONS RE-TOLERANCED FOR EASE OF MANUFACTURE. SECTION F-F & G-G ADDED.	AJS	13.07.18
B	ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). REASON: PARITY-197.	MB	12.06.15
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED	JP		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.18		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3913 SHEET 1 OF 8 TITLE LONG BASKET BASE ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

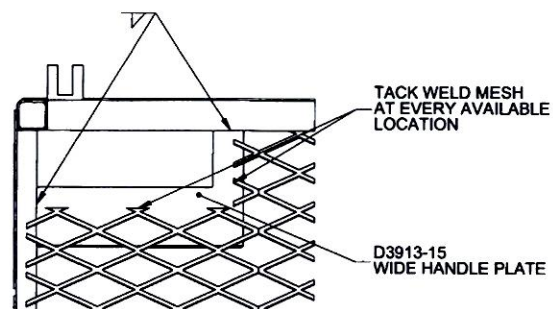




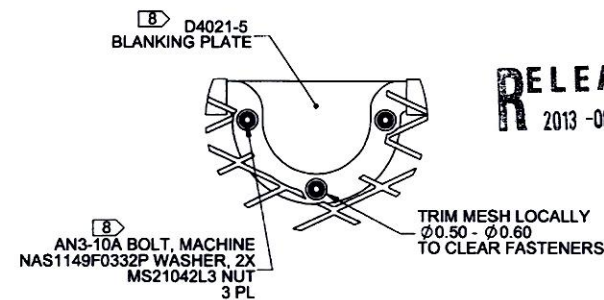
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATES

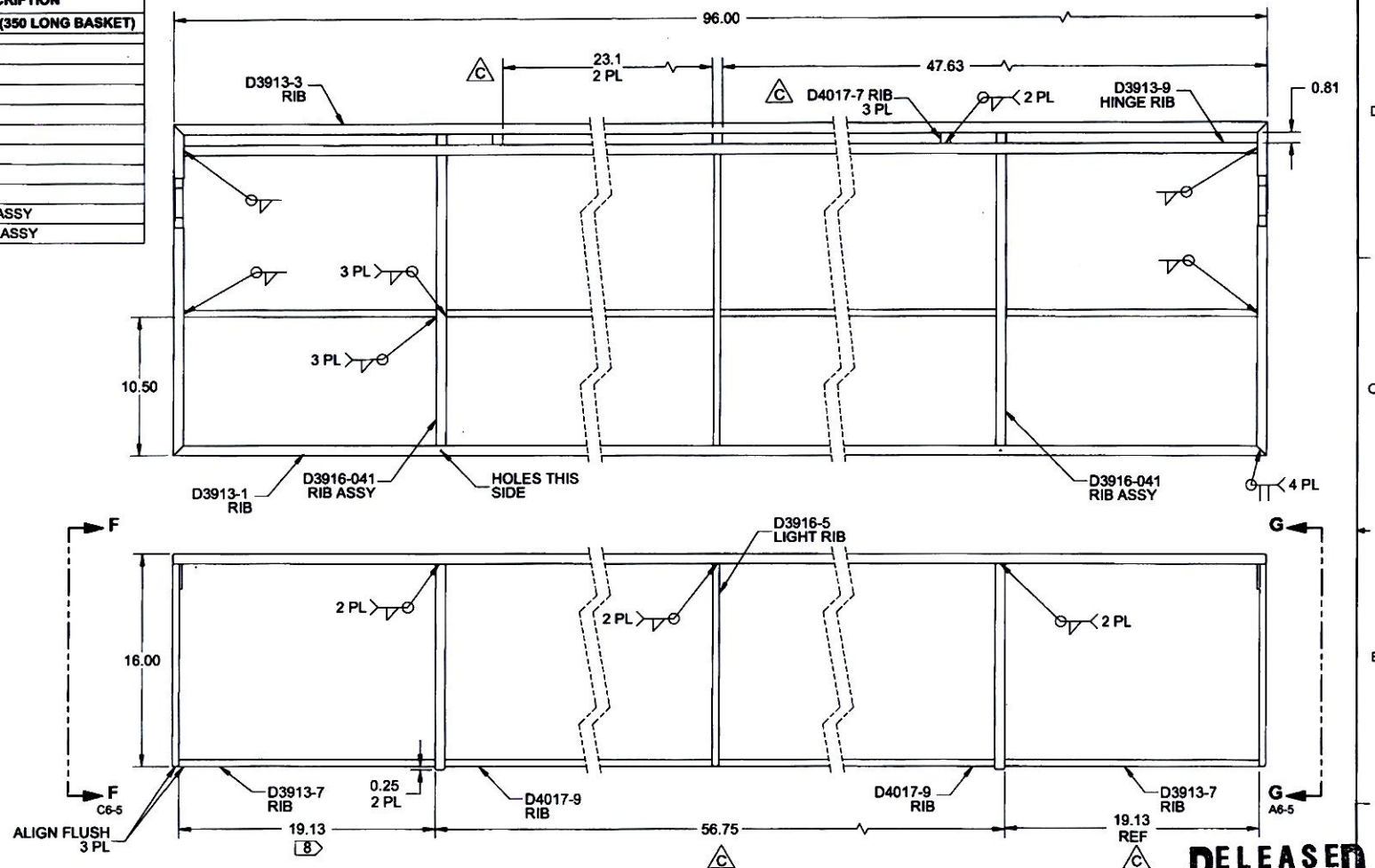


DETAIL D2-3
D6-3

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-08-16
WJ

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	3	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY

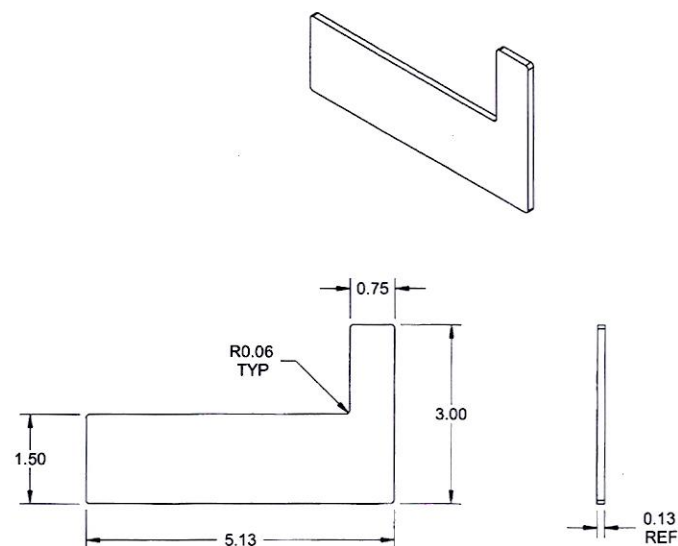
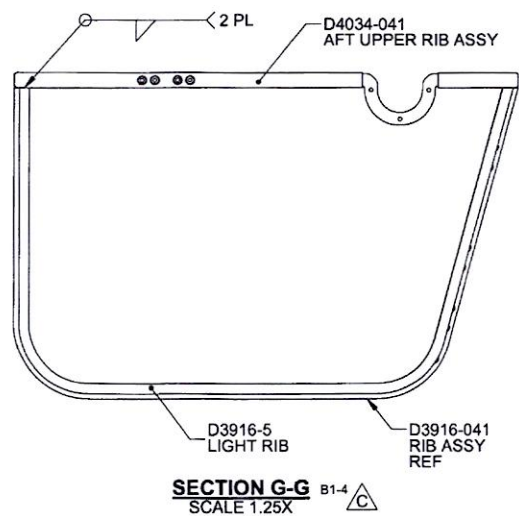
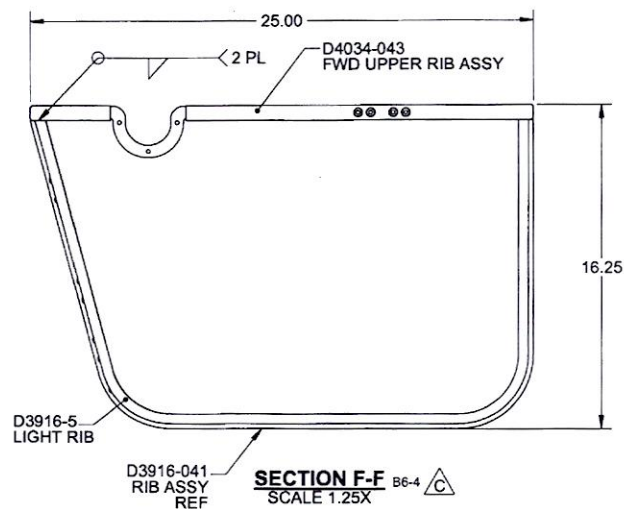


- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.65 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 - 9) WELD PER DART QSI 004

D3913-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2013-08-16



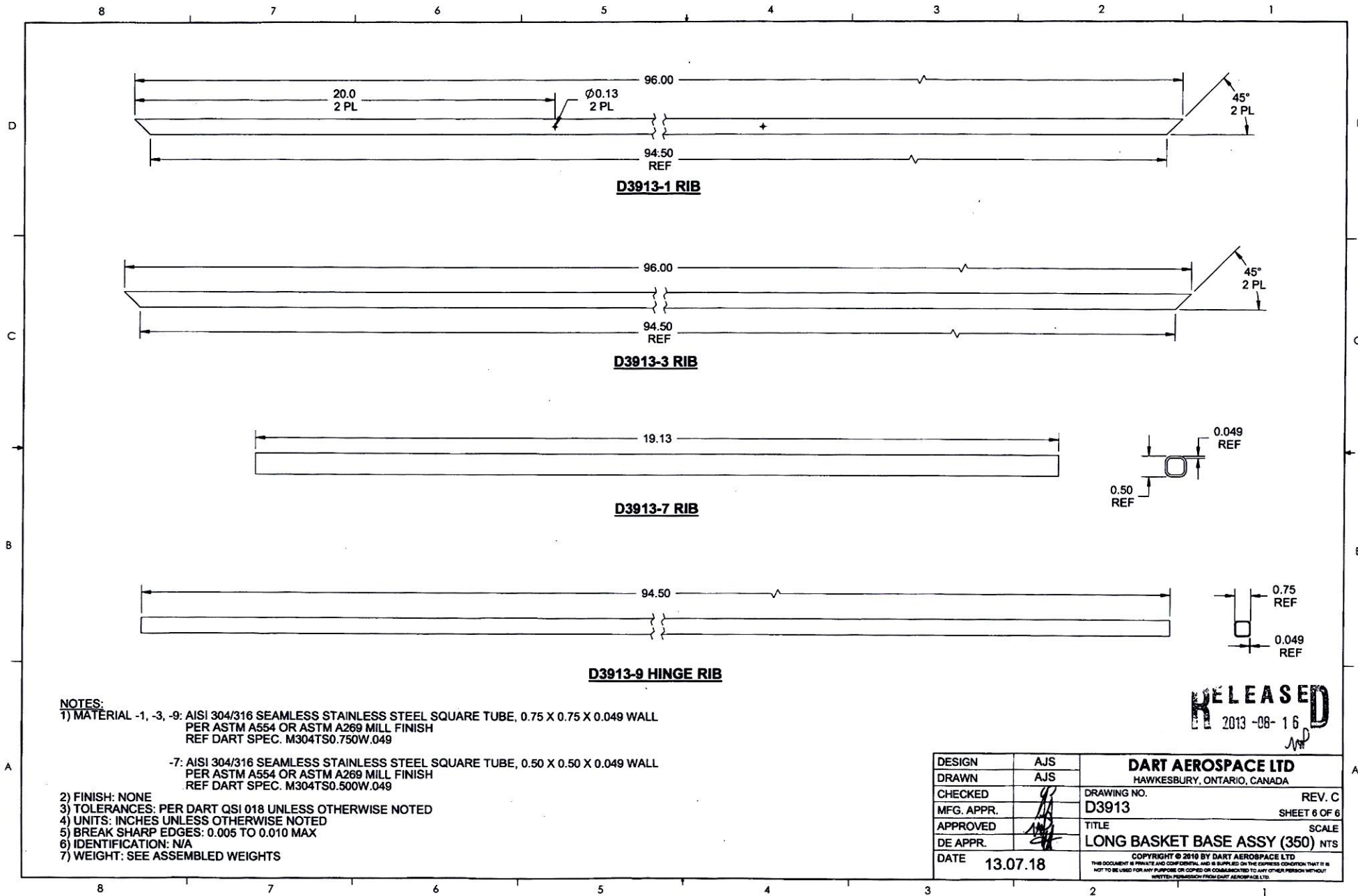
D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

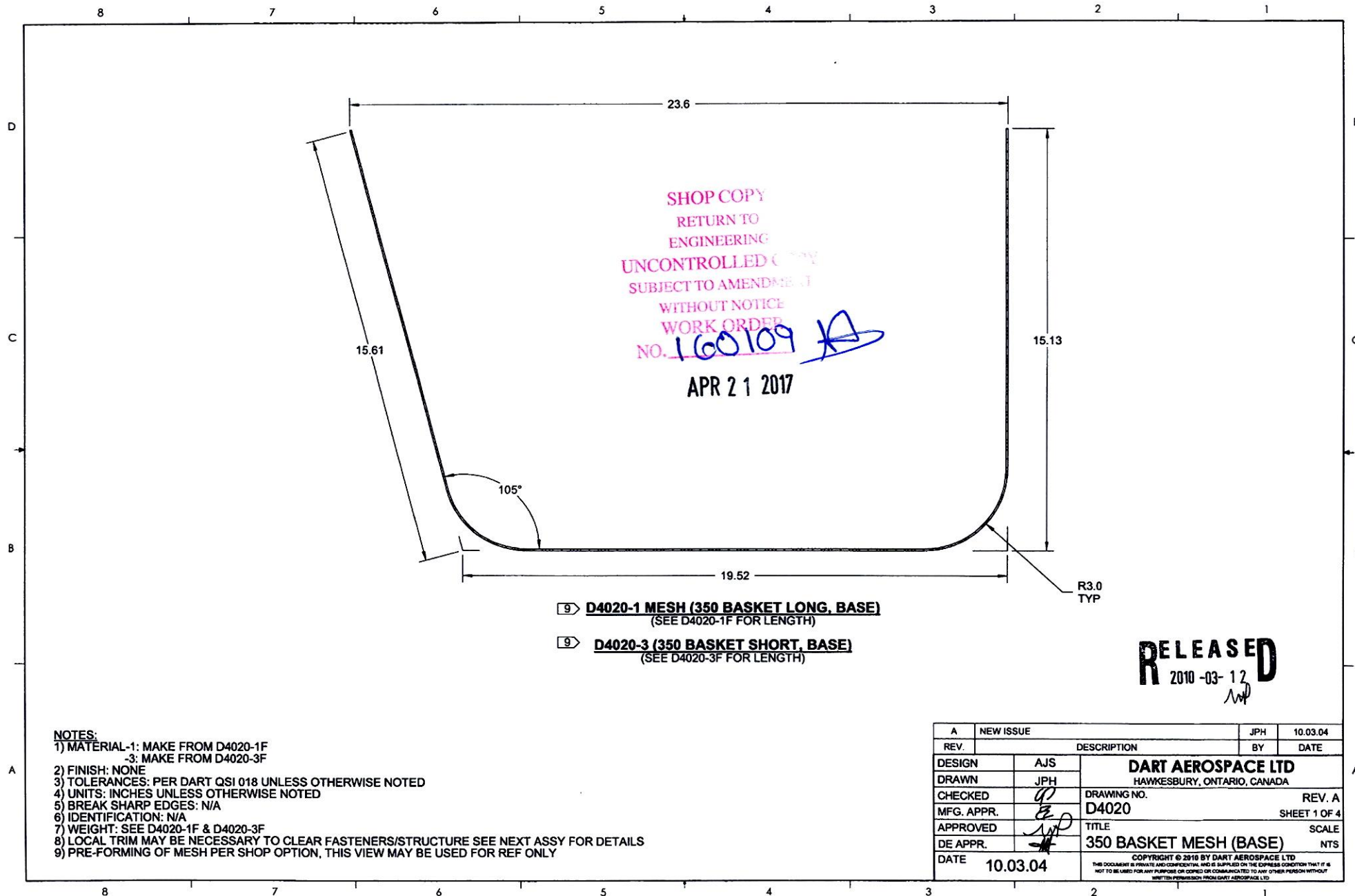
RELEASED
2013-08-16

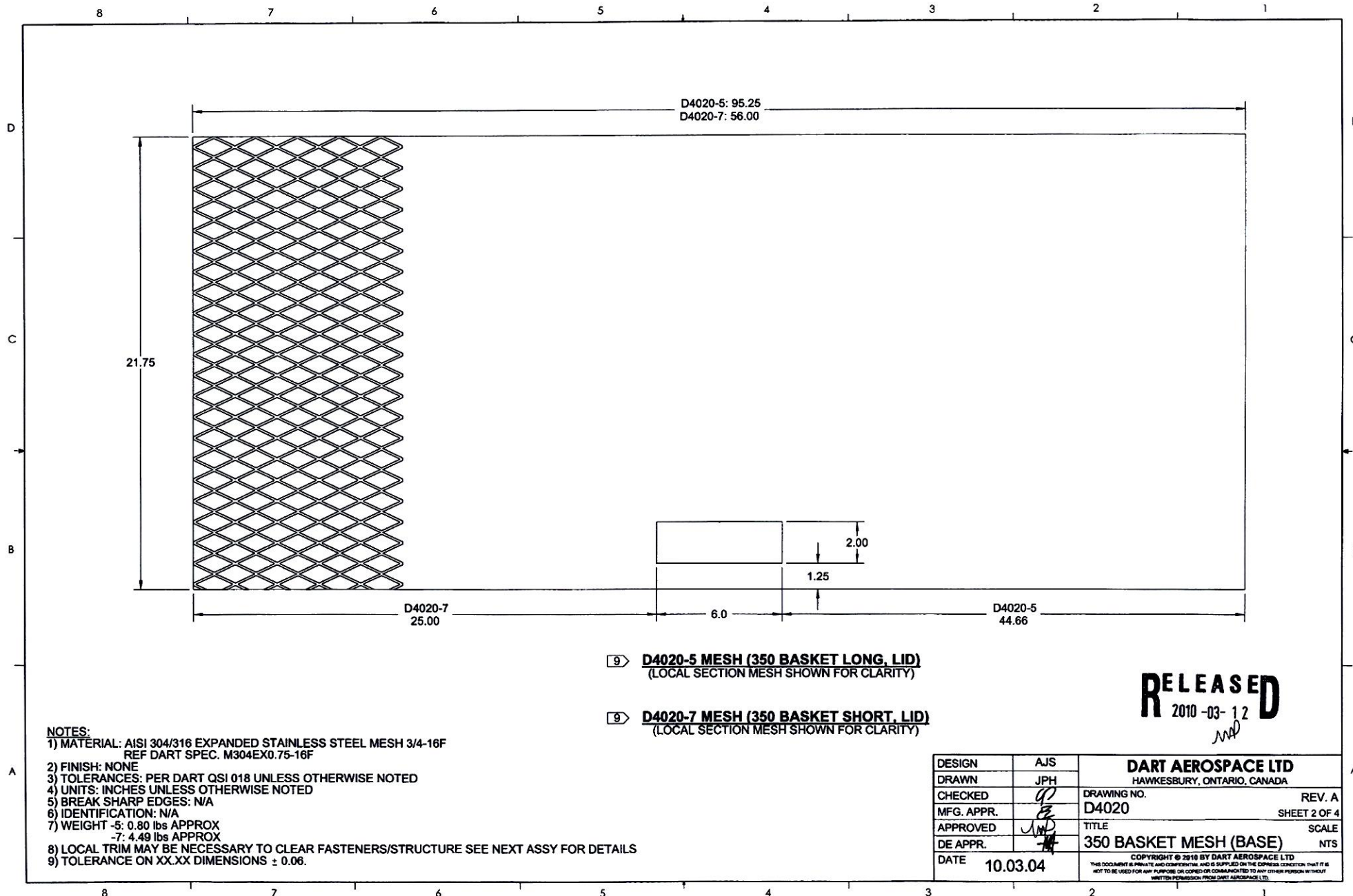
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3913	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350) NTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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CHECKED	<i>[Signature]</i>	DRAWING NO. D3913	REV. C
MFG. APPR.	<i>[Signature]</i>	TITLE LONG BASKET BASE ASSY (350)	SCALE NTS
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DE APPR.	<i>[Signature]</i>		
DATE	13.07.18		





NOTES:

1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT -5: 0.80 lbs APPROX

-7: 4.49 lbs APPROX

8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS

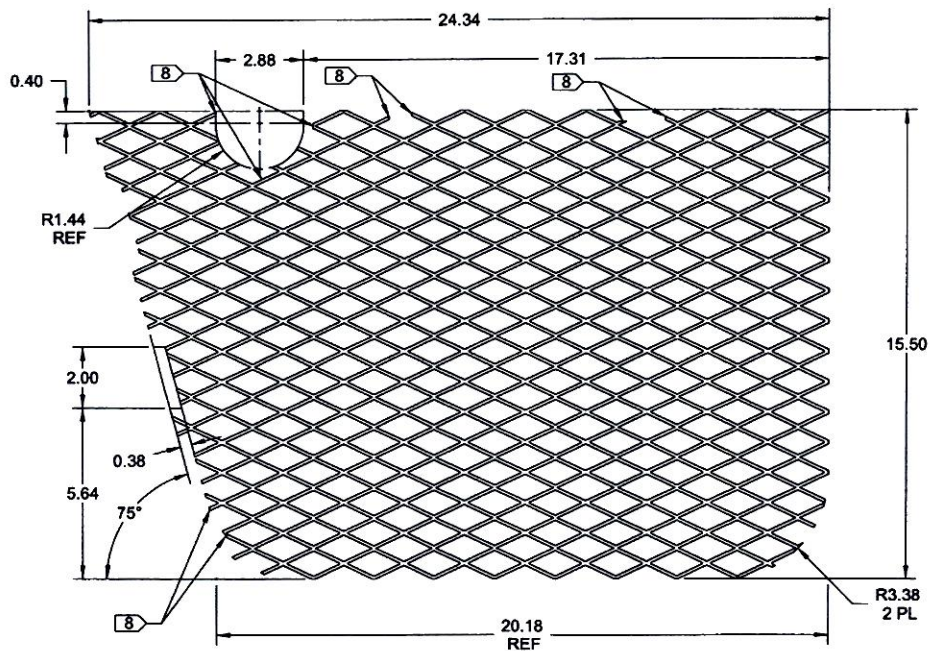
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

9 D4020-5 MESH (350 BASKET LONG, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

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CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4020	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
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9) **D4020-11 END MESH, BASKET**

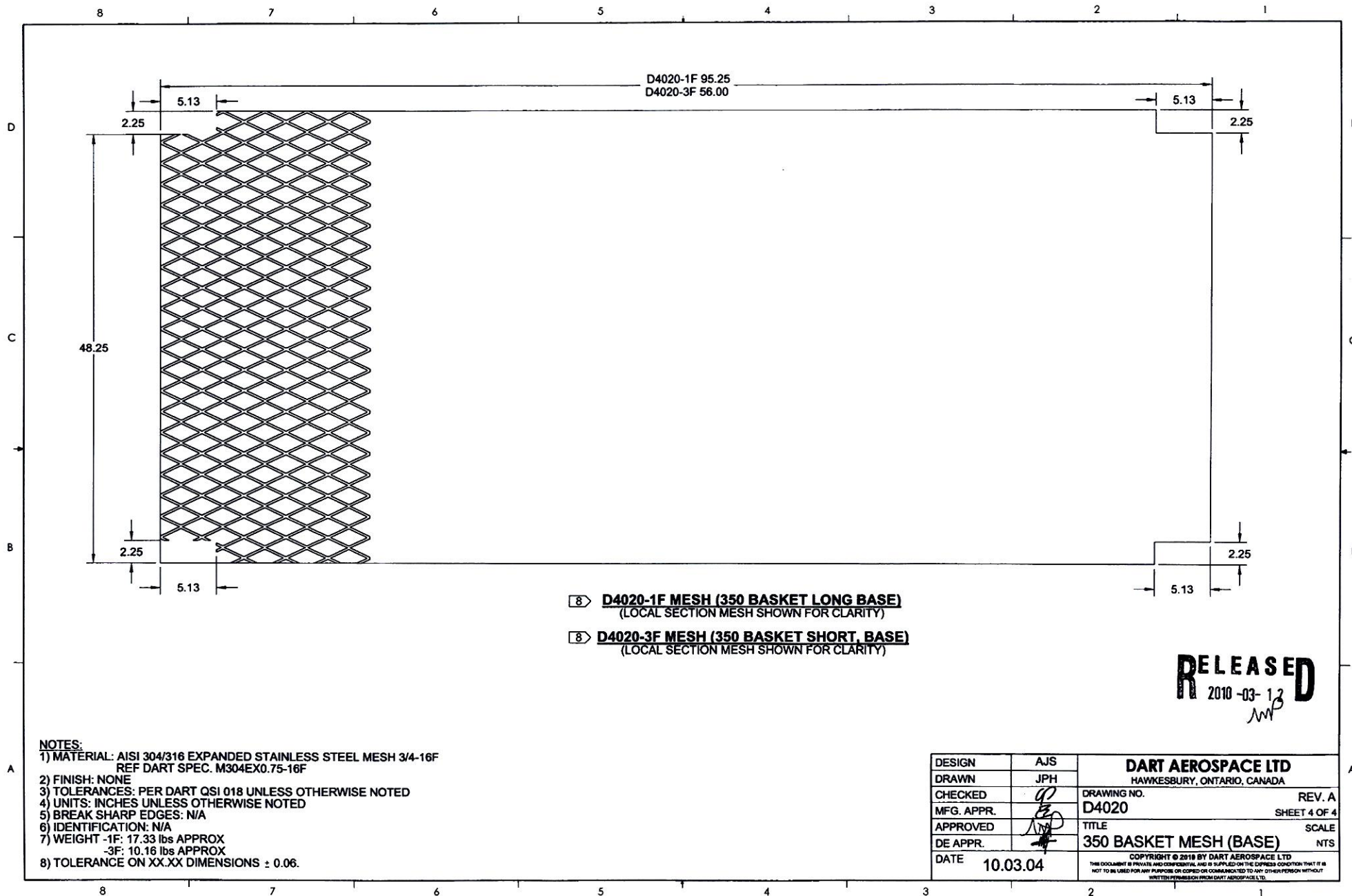
NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	
DATE	10.03.04	NTS	

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 REV. D
REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: 10016996

1.0 PURPOSE

This Dart Service Instruction provides parts and instructions for modifying the D350-607-541/-543/-545/-547 Heli-Utility-Basket Assemblies for specialty mission equipment.

The DSI 9776-011/-013/-15 kits consist of the parts required to modify the basket base assembly of D350-607-541/-543/-545/-547 Heli-Utility-Basket Assemblies.

Note: All dimensions shown in parentheses [] are in millimeters, otherwise in inches.
It is not mandatory for all of the covers shown in this DSI Installation be installed.
Although not normally required, it is permissible for operators to use longer or shorter bolts and thinner or thicker washers to ensure that all fasteners are in safety (minimum of 1.5 threads exposed). **Bolts that do not have the minimum of 1.5 threads exposed after installation of the nut must be replaced with longer bolts by the customer.**
Min distance from edge of Basket to center of D5519-043 Doubler Assy = 5.5" [140 mm].
Min distance between D5519-043 Doubler Assy (measured center to center) = 7.0" [178 mm].
D5519-043 Doubler Assy cannot be placed over the basket ribs.
D5519-043 Doubler must be installed on the flat portion of the expanded metal (Bottom or sides of basket).
All welding must be per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.

2.0 INSTALLATION OF DSI 9776-011 END COVER KIT (Short Basket Assembly):

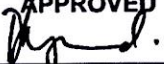
Note: This section provides instructions to install a D5519-041 Doubler Assy with a D5519-3 Cover Plate in both ends of the basket. It is also acceptable to install these parts at one end of the basket only.

- 2.1 At the customer's discretion, disassemble D4032-041 Short Basket Assembly by removing D4018-041/D4019-041 Short Basket Lid Assembly and retain hardware to facilitate this modification.
- 2.2 Locate the D3916-041 Rib Assembly at each end of the D4017-041 Short Basket Base Assy as shown in Figure 3. Partially remove the expanded metal as shown in Figure 3 Sections C-C & D-D.
- 2.3 Mark and drill 2x 0.375" holes at each end of the D3916-041 Rib Assemblies as shown in Figure 2 per Section A-A & B-B. Countersink 0.375" holes in the rib to 0.435 x 45 on both sides of the ribs. Deburr holes.
- 2.4 Drill 4x 0.098" (#40 drill) for MS21059L3 anchor nuts thru only the wall of each of the D3916-041 Rib Assembly on the D4017-041 Short Basket Base Assy as shown in Figure 2. Deburr holes.
- 2.5 Weld 4x D4021-9 Bushings into 0.375" holes and grind flush on both sides of the D4016-041 Rib Assemblies per Figure 2.
- 2.6 Install MS21059L3 anchor nuts per Figure 3.
- 2.7 Temporarily position the D5519-041 Doubler Assy by aligning the two bottom holes with the two bottom bushing holes on each of the D3916-041 Rib Assy. Locally trim (0.13" - 0.25") the expanded metal that overlaps with any of the MS21059L3 anchor nuts as shown in Figure 3 Section C-C and D-D.
- 2.8 Tig weld (tack weld) expanded metal at every available location attaching the D5519-041 Doubler Assy to the D3916-041 Rib Assemblies. Also tack weld the two packers into the bottom with the D3916-041 Rib Assemblies.
- 2.9 If incorporating this DSI during basket production, powder coat entire basket base per D4017 drawing. Mask MS21059L3 anchor nut holes prior to powder coat.
- 2.10 If incorporating this DSI post basket production, paint repaired areas per ICA-D350-607.

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DAO #01-O-01

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BY: 
D. SHEPHERD (DE # 02)

DATE: 17.03.21
CERT. NO.: SH94-14
ISSUE NO.: 7

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A	NEW ISSUE	RF	17.03.21
REV.	DESCRIPTION	BY	DATE
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JFS	DSI 9776	SHEET 1 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	D9	BASKET MODIFICATION	NTS
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- 2.11 Install a D5519-3 Cover plate onto each end of the D4017-041 Basket Base Assy using hardware as shown in Figure 1.
- 2.12 If applicable, re-assemble the modified D4032-041 Short Basket Assembly by attaching the modified D4017-041 Short Basket Base Assy to D4018-041/D4019-041 Short Basket Lid Assembly with the retained hardware.
- 2.13 Re-install basket per ICA-D350-607. Replace any worn hardware as necessary per Chapter 5 of ICA-D350-607.
- 2.14 Update the aircraft log book to indicate installation of the DSI 9776-011 End Cover Kit. Update the aircraft Weight and Balance per Section 7.0.

3.0 INSTALLATION OF DSI 9776-013 END COVER KIT (Long Basket Assembly):

Note: This section provides instructions to install a D5519-041 Doubler Assy with D5519-3 Cover Plate in both ends of the basket. It is also acceptable to install these parts at one end of the basket only.

- 3.1 At the customer's discretion, disassemble D4030-041 Long Basket Assembly by removing D3914-041/D3915-041 Long Basket Lid Assembly and retain hardware to facilitate this modification.
- 3.2 Locate the D3916-5 Rib at each end of the D3913-041 Long Basket Base Assy as shown in Figure 8. Partially remove the expanded metal as shown in Figure 8 Sections G-G & H-H.
- 3.3 Mark and drill 2x 0.297" holes at each end of the D3916-5 ribs as shown in Figure 7 Section E-E & F-F. Countersink 0.297" holes in the ribs to 0.357 x 45 in both sides of the ribs. Deburr holes.
- 3.4 Drill 4x 0.098" (#40 drill) for MS21059L3 anchor nuts thru only the wall of each of the D3916-5 Ribs on the D3913-041 Long Basket Base Assy as shown in Figure 7. Deburr holes.
- 3.5 Weld 4x D5338-1 Bushings into the 0.297" holes and grind flush on both sides of the D3916-5 Ribs.
- 3.6 Install MS21059L3 anchor nuts per Figure 8.
- 3.7 Temporarily position the D5519-041 Doubler Assemblies by aligning the two bottom holes with the two bottom bushing holes on each of the D3916-5 Ribs. Locally trim (0.13" - 0.25") the expanded metal that overlaps with any of the MS21059L3 anchor nuts as shown in Figure 8 Section G-G and H-H.
- 3.8 Tig weld (tack weld) expanded metal at every available location attaching the D5519-041 Doubler Assy on the D3916-5 Ribs. Also tack weld the two packers into the bottom with the D3916-5 Ribs.
- 3.9 If incorporating this DSI during basket production, powder coat entire basket base per D3913 drawing. Mask MS21059L3 anchor nut holes prior to powder coat.
- 3.10 If incorporating this DSI post basket production, paint repaired areas per ICA-D350-607.
- 3.11 Install a D5519-3 Cover plate onto each end of the D3913-041 Long Basket Base Assy using hardware as shown in Figure 6.
- 3.12 If applicable, re-assemble the modified D4030-041 Long Basket Assembly by attaching modified D3913-041 Long Basket Base Assy to D3914-041/D3915-041 Long Basket Lid Assembly with the retained hardware.
- 3.13 Re-install basket per ICA-D350-607. Replace any worn hardware as necessary per Chapter 5 of ICA-D350-607.
- 3.14 Update the aircraft log book to indicate installation of the DSI 9776-013 End Cover Kit. Update the aircraft Weight and Balance per Section 7.0.

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4.0 INSTALLATION OF DSI 9776-015 ROUND COVER KIT (Short Basket Assembly):

Note: This section provides instructions to install 4x D5519-043 Doubler Assy with 4x D5519-9 Cover Plates on the bottom base of the D4017-041 Short Basket Base Assy. It is also acceptable to install a portion of the DSI 9776-015 Kit.

- 4.1 Temporarily position 4x D5519-043 Doubler Assemblies on the base of the expanded metal of the D4017-041 Basket Base Assy. Mark and trim 4.40" from the center of the doubler assemblies. Locally trim (0.13" - 0.25") the expanded metal that overlaps any of the MS21059L3 anchor nuts as shown in Figure 5.
- 4.2 Tig weld (tack weld) expanded metal at every available location with the D5519-043 Doubler Assy.
- 4.3 If incorporating this DSI during basket production, powder coat entire basket base per D4017 drawing. Mask MS21059L3 anchor nut holes prior to powder coat.
- 4.4 If incorporating this DSI post basket production, paint repaired areas per ICA-D350-607.
- 4.5 Install 4x D5519-9 Cover plates onto the bottom of the D4017-041 Short Basket Base Assy using hardware as shown in Figure 4.
- 4.6 If applicable, re-assemble the modified D4032-041 Short Basket Assembly by attaching the modified D4017-041 Short Basket Base Assy to D4018-041/D4019-041 Short Basket Lid Assembly with the retained hardware.
- 4.7 Re-install basket per ICA-D350-607. Replace any worn hardware as necessary per Chapter 5 of ICA-D350-607.
- 4.8 Update the aircraft log book to indicate installation of the DSI 9776-015 Round Cover Kit. Update the aircraft Weight and Balance per Section 7.0

5.0 INSTALLATION OF DSI 9776-015 ROUND COVER KIT (Long Basket Assembly):

Note: This section provides instructions to install 4x D5519-043 Doubler Assy with 4x D5519-9 Cover Plates on the bottom base of the D3913-041 Long Basket Base Assy. It is also acceptable to install a portion of the DSI 9776-015 Kit.

- 5.1 Temporarily position 4x D5519-043 Doubler Assemblies on the base of the expanded metal of D3913-041 Long Basket Base Assy. Mark and trim 4.40" from the center of the D5519-043 Doubler Assemblies. Locally trim (0.13" - 0.25") the expanded metal that overlaps any of the MS21059L3 anchor nuts as shown in Figure 10.
- 5.2 Tig weld (tack weld) expanded metal at every available location with the D5519-043 Doubler Assy.
- 5.3 If incorporating this DSI during basket production, powder coat entire basket base per D3913 drawing. Mask MS21059L3 anchor nut holes prior to powder coat.
- 5.4 If incorporating this DSI post basket production, paint repaired areas per ICA-D350-607.
- 5.5 Install 4x D5519-3 Cover plates onto the bottom of the D3913-041 Long Basket Base Assy using hardware as shown in Figure 9.
- 5.6 If applicable, re-assemble the modified D4030-041 Long Basket Assembly by attaching the modified D3913-041 Long Basket Base Assy to D3914-041/D3915-041 Long Basket Lid Assembly with the retained hardware.
- 5.7 Re-install basket per ICA-D350-607. Replace any worn hardware as necessary per Chapter 5 of ICA-D350-607.
- 5.8 Update the aircraft log book to indicate installation of the DSI 9776-015 Round Cover Kit. Update the aircraft Weight and Balance per Section 7.0

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APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET MODIFICATION	NTS
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6.0 PARTS LIST

QTY -011	QTY -013	QTY -015	PART NUMBER	DESCRIPTION
X			DSI 9776-011	END COVER KIT (SHORT BASKET)
	X		DSI 9776-013	END COVER KIT (LONG BASKET)
		X	DSI 9776-015	ROUND COVER KIT (SHORT/LONG BASKET)
	4		D4021-9	BUSHING
4			D5338-1	BUSHING
2	2		D5519-041	DOUBLER ASSEMBLY
		4	D5519-043	DOUBLER ASSEMBLY
2	2		D5519-3	COVER PLATE
		4	D5519-9	COVER PLATE
16	16	16	AN3-3A	BOLT
4	4		AN3-12A	BOLT
8	8		CCR274CS-3-02	RIVET, BLIND
20	20	16	NAS1149F0332P	WASHER

7.0 WEIGHT AND BALANCE:

The weight of these kits is added to the basket weight. It is the responsibility of the installer to ensure the limitations of FMS-D350-607 and FMS-D355-607 are not exceeded and to update the weight and balance information included in D350-607-3 and ICA-D350-607.

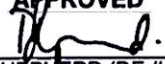
Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9776-011 End Cover Kit (Short Basket)	5.4 lb 2.4 kg	+/- 49.1 in +/- 1.25 m	+/- 265 in-lb +/- 3.0 m-kG	135 in 3.43 m	729 in-lb 8.2 m-kG
DSI 9776-013 End Cover Kit (Long Basket)	5.4 lb 2.4 kg	+/- 49.1 in +/- 1.25 m	+/- 265 in-lb +/- 3.0 m-kG	135 in 3.43 m	729 in-lb 8.2 m-kG
DSI 9776-015 Round Cover Kit (Short/Long Basket)	1.5 lb 0.7 kg	+/- 52.0 in +/- 1.32 m	+/- 78 in-lb +/- 0.9 m-kG	135 in 3.43 m	202 in-lb 2.4 m-kG

8.0 OPERATIONAL REQUIREMENTS:

- All equipment installed in the basket must be mechanically fastened to the basket if the D5519-3/-9 Covers Plate are removed.
- Only covers required for specific mission equipment should be removed.
- Equipment must not extend further than 6" (152 mm) beyond the outer edge of the basket.
- If basket is used for regular missions (ie hauling loose cargo), all covers must be installed.

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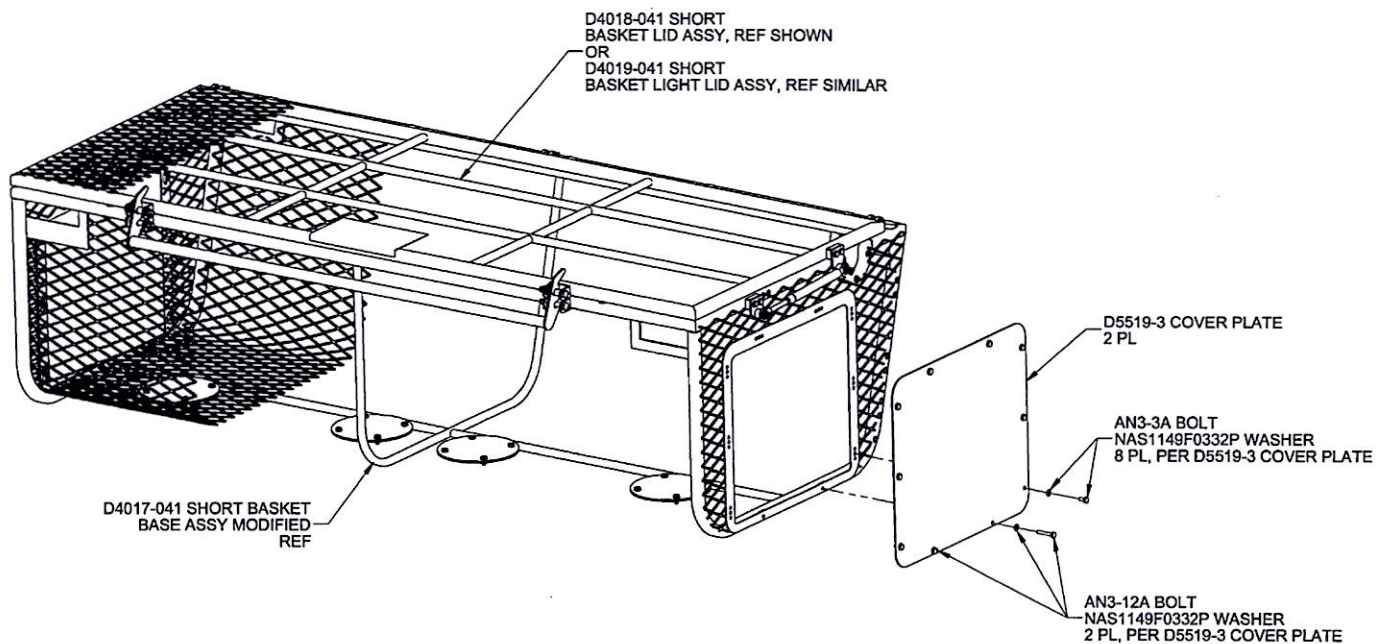
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**FIGURE 1 - DSI 9776-011 END COVER KIT INSTALLATION
ON D4032-041 SHORT BASKET ASSY**
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

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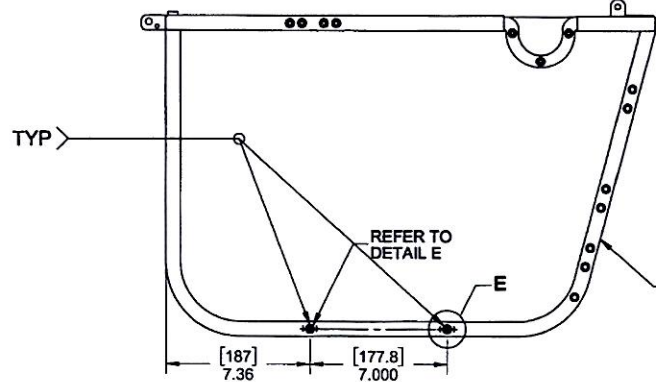
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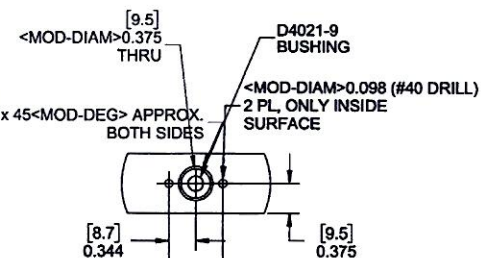
DESIGN	RF	DART AEROSPACE LTD	
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MFG. APPR.	JFS	DSI 9776	SHEET 5 OF 14
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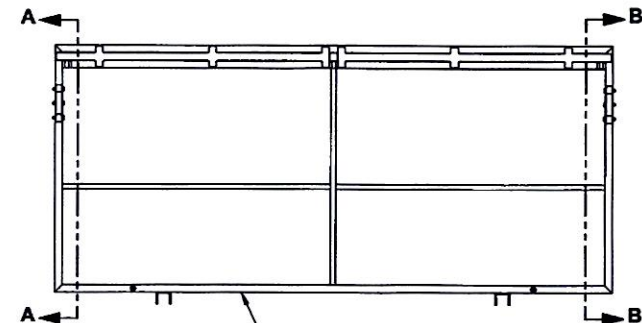
SECTION A-A SHOWN
(SECTION B-B OPPOSITE)

D3916-041
RIB ASSY
REF

CSK <MOD-DIAM>0.435 x 45<MOD-DEG> APPROX.
[11]



DETAIL E
2 PL



D4017-041 SHORT
BASKET BASE MODIFIED, REF

FIGURE 2 - DSI 9776-011 END COVER KIT INSTALLATION
ON D4032-041 SHORT BASKET ASSY - DETAIL
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

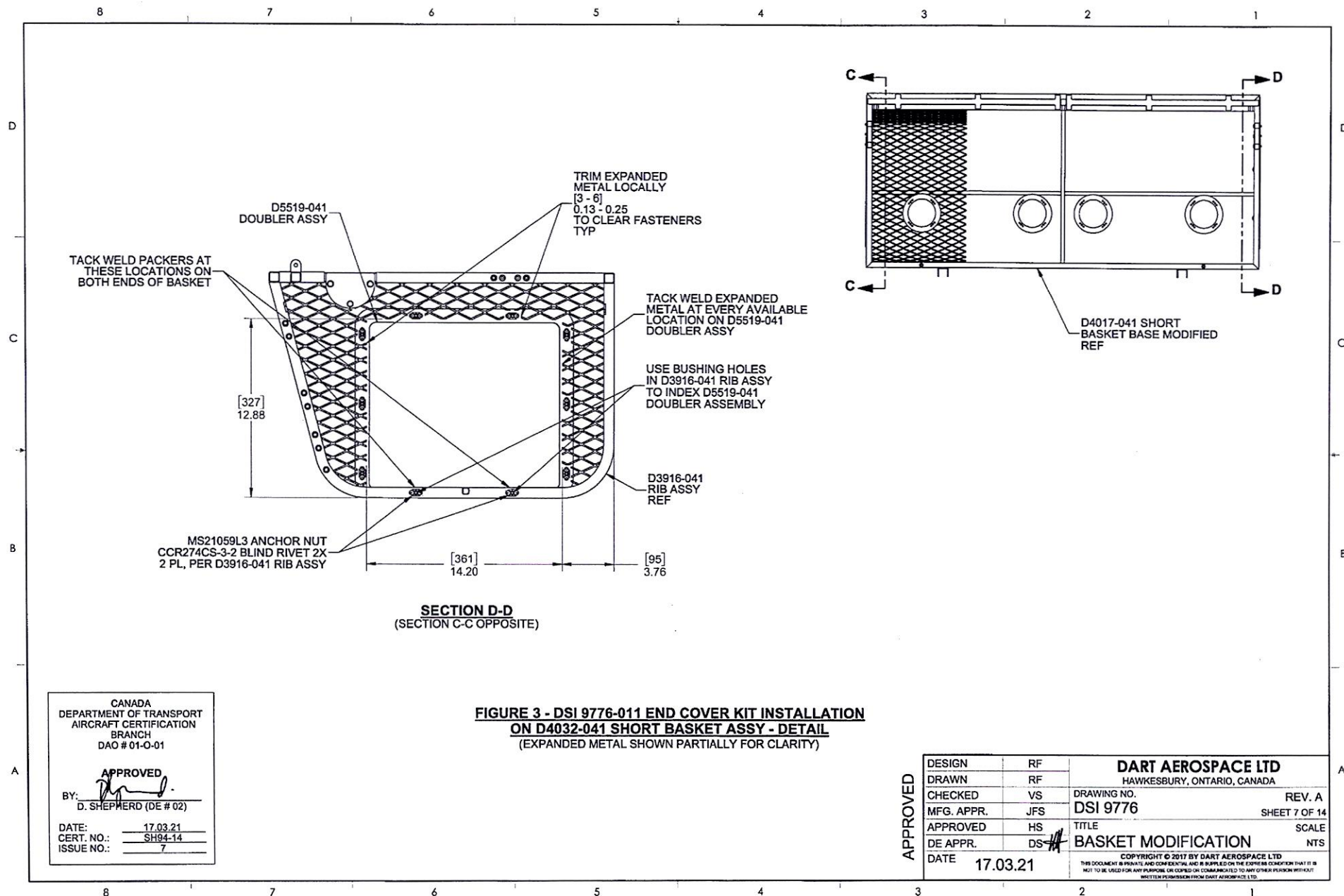
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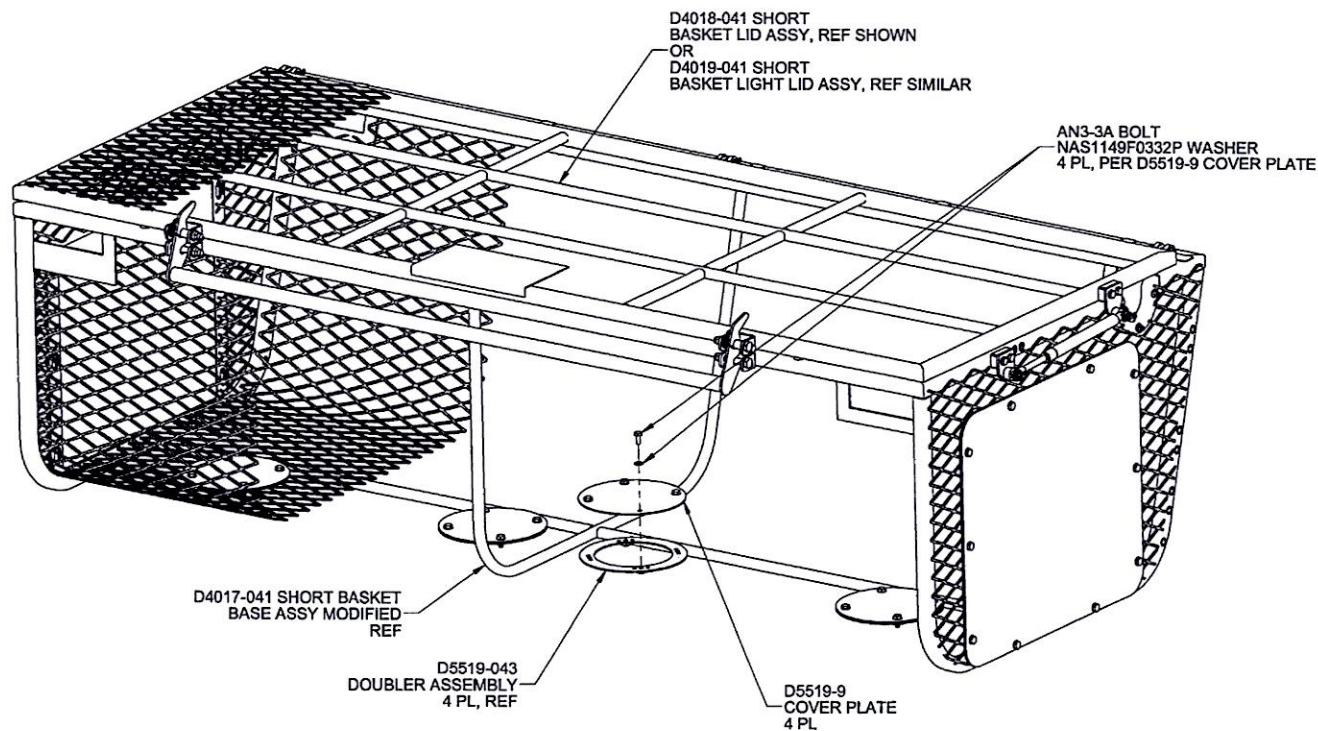


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FIGURE 3 - DSI 9776-011 END COVER KIT INSTALLATION ON D4032-041 SHORT BASKET ASSY - DETAIL
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

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**FIGURE 4 - DSI 9776-015 ROUND COVER KIT INSTALLATION
ON D4032-041 SHORT BASKET ASSY**
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

TRIM
EXPANDED METAL
[112]
TO <MOD-DIAM>4.40
4 PL

TRIM EXPANDED
METAL LOCALLY
[3 - 6]
0.13 - 0.25
TO CLEAR MS21059L3
ANCHOR NUT
TYP

TACK WELD EXPANDED
METAL AT EVERY AVAILABLE
LOCATION ON D5519-043
DOUBLER ASSY
TYP

D4017-041 SHORT BASKET
BASE ASSY MODIFIED
REF

[203]
8.00
REF

[406]
16.00
REF

[406]
16.00
REF

[203]
8.00
REF

[199]
7.85
REF

D5519-043
DOUBLER ASSY
4 PL

FIGURE 5 - DSI 9776-015 ROUND COVERS KIT INSTALLATION
ON D4032-041 SHORT BASKET ASSY - DETAIL
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)
(QUANTITY OF D5519-043 DOUBLER ASSY AND DIMENSIONS SHOWN ARE PER CUSTOMER PREFERENCES)

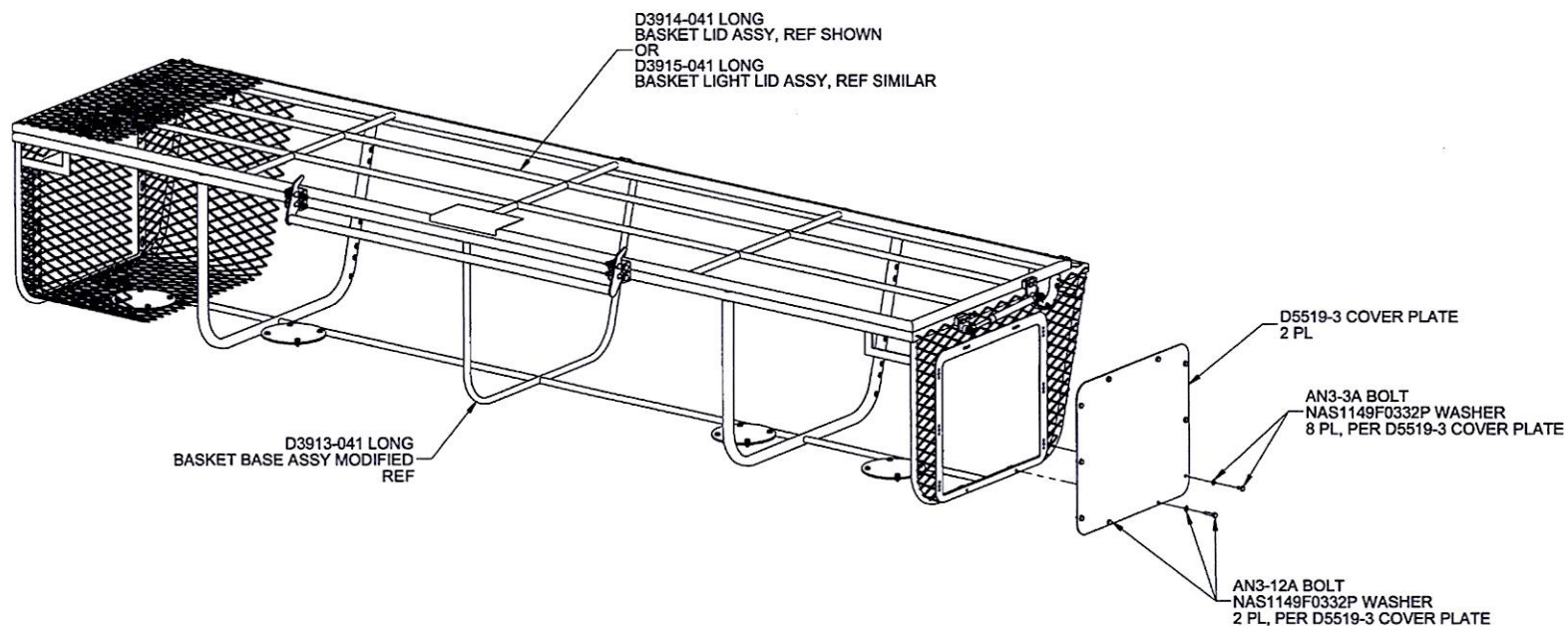
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8 7 6 5 4 3 2 1



**FIGURE 6 - DSI 9776-013 END COVER KIT INSTALLATION
ON D4030-041 LONG BASKET ASSY**
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

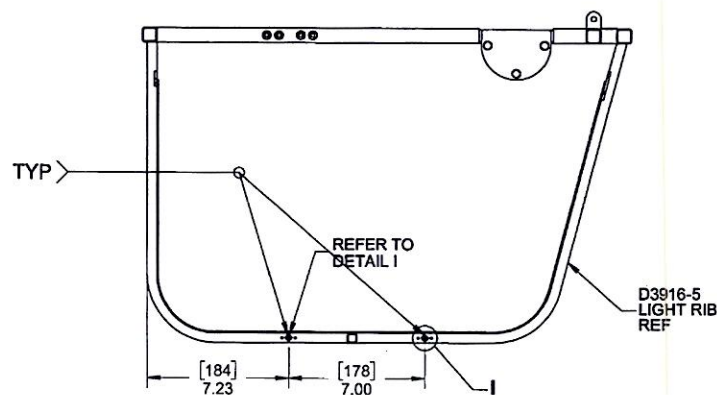
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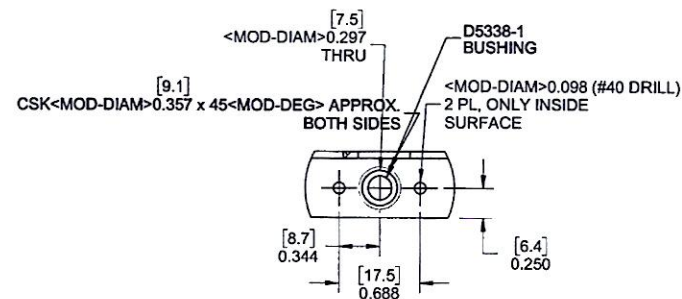
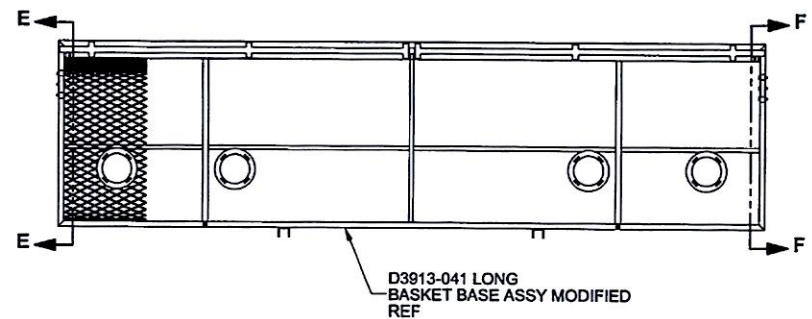
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SECTION E-E
(SECTION F-F OPPOSITE)



DETAIL I
2 PL

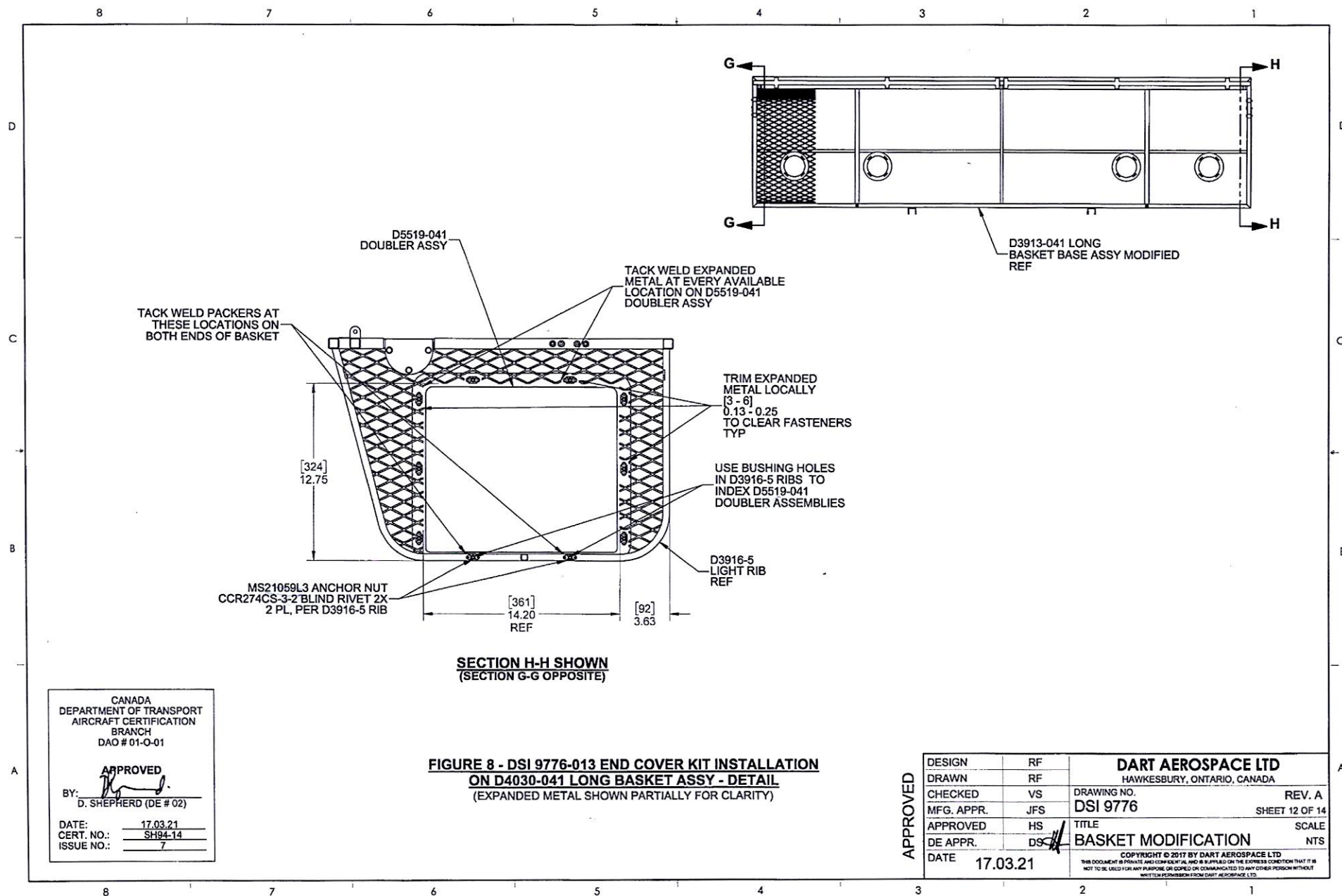
FIGURE 7 - DSI 9776-013 END COVER KIT INSTALLATION
ON D4030-041 LONG BASKET ASSY - DETAIL
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

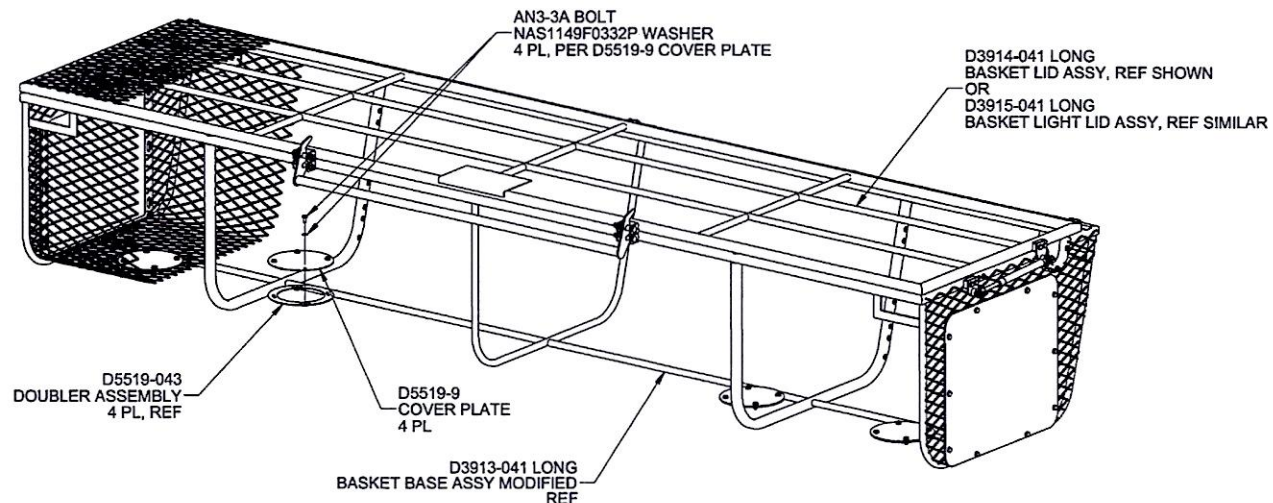
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**FIGURE 9 - DSI 9776-015 ROUND COVER KIT INSTALLATION
ON D4030-041 LONG BASKET ASSY**
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

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